

# Work Order ID 79512

**\*79512\***

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January-26-12 4:05:57 PM

Item ID: D2667-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Aft Out 206  
 Start Date: 26/01/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 09/02/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2667	Rev D								

100 0.00  
**\*100\*** HAAS CNC VERTICAL MACHINING #1 TR/PO 12/03/24 4 1  
 HAAS 1 Memo 0.00  
 HAAS CNC vertical machine #1 Program batch number.1-Inspect part number and batch number are programmed correctly.3-Fixturing Inspection last completed on \_\_\_\_\_ by  
 4-Machine Step No 1 of Folio and visually inspect as per attached  
 Dimension Sheet 5-Machine Step No 2 of F

110 0.00  
**\*110\*** CONVENTIONAL MILLING MACHINE TR/PO 12/03/24 4 0  
 Mill Conv Memo 0.00  
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

120 0.00  
**\*120\*** QC2- Inspect parts off machine FAI/FAIB TR/PO 12/03/24 4 0  
 QC Memo 0.00  
 Quality Control

W/O: 79512		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D226072 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: OK Date: 12/03/29  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/3/29

NCR: 12-1295		WORK ORDER NON-CONFORMANCE (NCR) 187.14						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/24	100	OPERATOR ERROR WRONG ORIGIN Roughen went through The PART PART SCRAP	<u>100</u> 12/03/26 PST042	Scrap and destroy replace Batch #: <u>80765</u>	<u>PD</u> 12/03/24	<u>OK</u>	<u>OK</u> 12/03/26 PST042	<u>OK</u> 12/03/26

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 79512**

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**\*79512\***

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Item ID: D2667-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, RH Aft Out 206

Start Date: 26/01/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>42Z</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

4 BL 12-3-2612/3/26 (4)MLJ 12/03/27MLJ 12/03/27  
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 79512

**\*79512\***

Parent Item: D2667-2

**\*D2667-2\***

Parent Item Name: Saddle, RH Aft Out 206

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	120.0000	1	4			
<b>*D6101-003*</b>									<b>**</b>				

Saddle Billet, 7075

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	126	
73775	2	
73780	7	
78159	54	
78599	56	
MAT042	-7	
MAT044	1	
73769	1	

→ 80765

→ 80765

4  
+  
1

E.K 12/03/23

PO 12/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

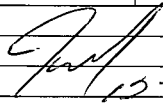



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	79512
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b>	D2667-2
<b>Inspection Dwg:</b> D2667 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2667 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.124	0.123	0.123		
B	0.100	0.140		0.124	0.120	0.120	0.122		
C	1.125	1.145		1.145	1.135	1.135	1.135		
D	0.615	0.685		0.675	0.675	0.675	0.675		
E	0.240	0.260		0.249	0.253	0.256	0.256		
F	1.313	1.343		1.332	1.333	1.333	1.330		
G	0.210	0.230		0.226	0.225	0.226	0.225		
H	0.100	0.180		0.135	0.130	0.130	0.130		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.585	1.571	1.574	1.574		
K	0.235	0.240		0.235	0.237	0.237	0.236		
L	0.100	0.120		0.120	0.110	0.110	0.110		
M	0.990	1.010		1.004	1.002	1.002	1.002		
N	0.510	0.515		0.513	0.512	0.512	0.517		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.313	0.313	0.313	0.313		
S	0.315	0.322		0.315	0.315	0.315	0.315		
T	1.995	2.005		1.998	2.000	2.000	2.000		
U	1.357	1.367		1.360	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.796	0.797	0.797		
W	1.040	1.060		1.052	1.050	1.050	1.050		
X	1.674	1.679		1.678	1.679	1.679	1.679		
Y	0.257	0.262		0.258	0.258	0.258	0.258		
Z	0.912	0.932		0.920	0.921	0.921	0.923		
AA	0.490	0.510		0.504	0.500	0.501	0.500		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	PO/PA
Date:	12/03/24

Audited by:	
Date:	12-03-24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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